

Date: Tuesday, 1/31/2006 11:04:13 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT GUSSET (350) BASKET
Job Number : 25687	
Estimate Number : 10496	
P.O. Number : N/A	Part Number : D2325
This Issue : 1/31/2006 S.O. No. : N/A	Drawing Number : D2325 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 24529	Material : N/A
Written By : <u>SEE COMMENT BEKW</u>	Due Date : 2/7/2006 Qty: 100 Um: Each
Checked & Approved By : <u>06-01-31</u>	
Comment : Est. D 02.12.06 Reformat; Rev B, KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 498

Email or ship DXF file to vendor Make as per Dwg D2325,

Material: 304 SS .063" Thick

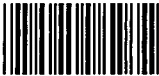
Material release note required

06-02-01

2.0

D2325F

Support Gusset (350 Bask



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)
 Support Gusset (350 Bask

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

06-02-08 (100)

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06-02-08 (100)

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary

06-02-09 (100)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 06/02/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/31/2006 11:04:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT GUSSET (350) BASKET

Job Number: 25687

Part Number: D2325

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGIN

Identify and Stock

Location: WS3

CY 06/02/09 100

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/02/10

(100)

SD 06/02/10

100

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

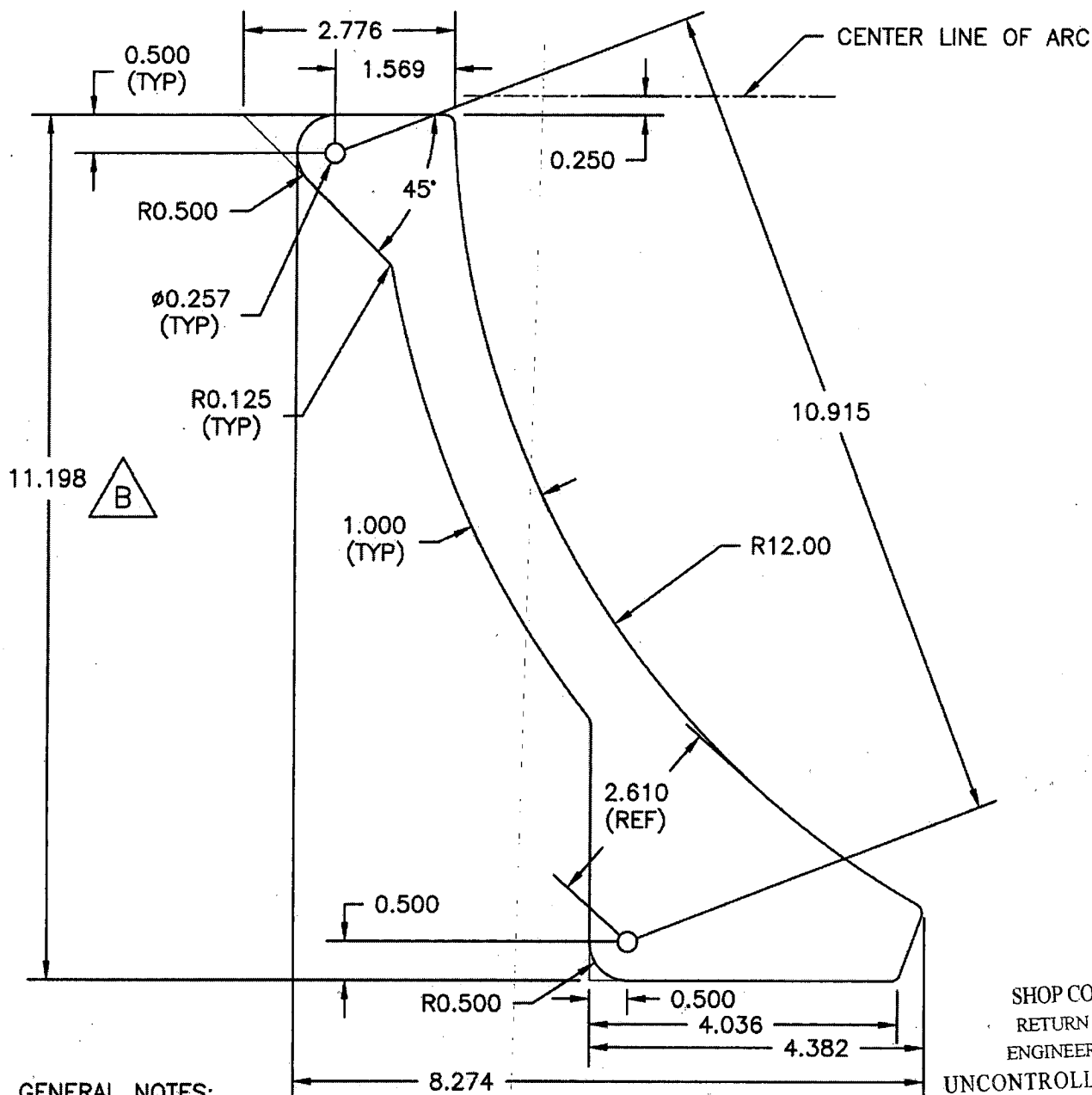
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2325	REV. B SHEET 1 OF 1
DATE 02.08.28		TITLE SUPPORT GUSSET	SCALE 1:2
A	94.12.13	NEW ISSUE	
B	02.08.28	REFORMAT; 11.198 WAS 11.948	

RELEASED
02.08.29**GENERAL NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.063 THICK (REF DART SPEC. M304S16GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25687

Copyright © 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

MATERIAL TEST/INSPECTION CERTIFICATE

95264006


 INVOICE NO.:
COMMODITY:

 F05M325R
PRIME COLD ROLLED STAINLESS STEEL SHEET

 工廠:高雄縣路竹鄉順安路345號
345, SHUN AN RD. LU CHU HSIAN
KAOHSIUNG TAIWAN R.C.C.
TEL:(07)8972885 FAX:(07)8973006
CERTIFICATE NO: F05M325R
DATE OF ISSUE:03/21/2005
PAGE:2

SPECIFICATION:

AISI 304

CUSTOMER:

INTEGRIS METALS LTD

SIZE	BUYER'S ITEM NUMBER	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test GL=50 mm					Chemical Composition (%)							
			KGS	LBS			Y.S. (N/mm ²)	T.S. (N/mm ²)	E.L. (%)	HRB	H V	C x100	Si x100	Mn x100	P x1000	S x1000	Ni x100	Cr x100	N x100
AISI 304 NO.4																			
14GA / 48" X 96"	(7426-9033)	1	1,448	3,192	YU233240	43S60721A-11	297	679	48	86	169	4	50	104	30	5	806	1813	2.4
14GA / 60" X 120"	(7426-9266)	1	1,420	3,131	YU233112	43S60768B-11	316	681	49	86	170	4.6	52	120	29	8	802	1806	2.8
14GA / 60" X 120"	(7426-9266)	1	1,355	2,987	YU233112	43S60768B-12	316	681	49	85	170	4.6	52	120	29	8	802	1808	2.8
12GA / 48" X 120"	(7427-4844)	1	1,444	3,183	YU136915	43S61039A-116	295	631	54	84	166	4.9	46	122	34	5	816	1829	2.9
12GA / 48" X 120"	(7427-4844)	1	634	1,508	YU136915	43S61039A-117	295	631	54	84	166	4.9	46	122	34	5	816	1829	2.9
11GA / 48" X 120"	(7427-7177)	1	1,400	3,085	YU136907	42S60091A-114	293	676	51	83	165	4.2	46	112	37	2	810	1819	2.8
11GA / 48" X 120"	(7427-7177)	1	1,398	3,082	YU136907	42S60091A-115	293	675	51	83	165	4.2	46	112	37	2	810	1819	2.8
11GA / 48" X 120"	(7427-7177)	1	1,398	3,082	YU136907	42S60091A-116	293	675	51	83	165	4.2	46	112	37	2	810	1819	2.8
11GA / 48" X 120"	(7427-7177)	1	958	2,112	YU136907	42S60091A-117	293	675	51	83	165	4.2	46	112	37	2	810	1819	2.8
AISI 304 2B																			
22GA / 48" X 120"	(7425-5951)	1	1,295	2,855	YU197010	43S61131A-31	284	655	53	83	163	5.2	48	128	32	10	805	1822	2.9
20GA / 48" X 96"	(7425-8310)	1	1,228	2,707	YU233131	42S60810A-32	271	676	51	83	163	3.9	44	117	29	7	811	1823	2.8
18GA / 48" X 120"	(7426-2619)	1	1,453	3,203	YU233278	43S60983B-3	288	673	50	81	157	3.9	49	115	28	5	810	1824	2.7
18GA / 48" X 96"	(7426-2494)	1	1,471	3,243	YU233278	43S60983B-4	288	673	50	81	157	3.9	49	115	28	5	810	1824	2.7
18GA / 48" X 96"	(7426-2494)	1	1,471	3,243	YU233278	43S60983B-5	288	673	50	81	157	3.9	49	115	28	5	810	1824	2.7
16GA / 48" X 120"	(7426-5166)	1	1,478	3,258	YU136978	43S60826A-1	302	659	50	82	161	4.1	48	124	29	4	805	1827	2.7
16GA / 48" X 96"	(7426-5059)	1	1,457	3,212	YU136978	43S60826A-3	302	659	50	82	161	4.1	48	124	29	4	805	1827	2.7
16GA / 60" X 120"	(7426-5497)	1	1,409	3,106	YU136837	43S61067A-21	294	665	50	81	157	4	48	111	30	4	808	1818	2.7
14GA / 48" X 120"	(7426-8053)	1	1,423	3,137	YU136975	43S60820A-5	293	646	51	82	162	4.5	48	122	29	4	807	1818	2.9
14GA / 48" X 120"	(7426-8053)	1	1,424	3,139	YU136975	43S60820A-6	293	646	51	82	162	4.5	48	122	29	4	807	1818	2.9
14GA / 48" X 120"	(7426-8053)	1	1,423	3,137	YU136975	43S60820A-7	293	646	51	82	162	4.5	48	122	29	4	807	1818	2.9
14GA / 48" X 96"	(7426-7949)	1	1,489	3,283	YU136975	43S60820A-8	293	646	51	82	162	4.5	48	122	29	4	807	1818	2.9
12GA / 48" X 120"	(7427-3699)	1	1,366	3,012	YU136915	43S61039B-16	295	631	54	84	166	4.9	46	122	34	5	816	1829	2.9
12GA / 48" X 120"	(7427-3699)	1	1,288	2,840	YU136915	43S61039B-17	295	631	54	84	166	4.9	46	122	34	5	816	1829	2.9
12GA / 48" X 144"	(7427-3830)	1	1,277	2,815	YU136915	43S61039B-11	295	631	54	84	166	4.9	46	122	34	5	816	1829	2.9
12GA / 48" X 96"	(7427-3541)	1	1,336	2,945	YU136915	43S61039B-13	295	631	54	84	166	4.9	46	122	34	5	816	1829	2.9
12GA / 60" X 96"	(7427-4085)	1	1,449	3,194	YU232886	42S67719A-211	304	675	49	84	167	4	52	124	24	7	812	1811	3
12GA / 60" X 96"	(7427-4085)	1	1,066	2,350	YU232886	42S67719A-212	304	675	49	84	167	4	52	124	24	7	812	1811	3
27			36,308	80,042															

Remarks:

NO MERCURY CONTAMINATION

Bend test: good for all Heat NO.

 WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.

 PRODUCT IN ACCORDANCE WITH ASTM A240, A480,
A262E, ASME SA240, Q35765D.
P.O. NO.: 434470

YIEH MAU CORP.

Manager of Quality Assurance Section

MATERIAL TEST/INSPECTION CERTIFICATE

90264011



YIEH MAU CORP.

INVOICE NO. :
COMMODITY :F06M326R
PRIME COLD ROLLED STAINLESS STEEL SHEET

工廠:高雄縣路竹鄉順安路345號
345, SHUN AN RD. LU CHU HSIAN
KAOHSIUNG TAIWAN R.O.C.
TEL:(07)5972885 FAX:(07)5973008
CERTIFICATE NO: F06M326R
DATE OF ISSUE:09/31/2005
PAGE:3

SPECIFICATION :
CUSTOMER :AISI 304
INTEGRIS METALS LTD

SIZE	BUYER'S ITEM NUMBER	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test GL=50 mm					Chemical Composition (%)								
			KGS	LBS			Y.S. (N/mm ²)	T.S. (N/mm ²)	E.L. (%)	HRB	H V	C x100	Si x100	Mn x100	P x1000	S x1000	Ni x100	Cr x100	N x100	
AISI 304 2B																				
11GA / 48" X 120"	(7427-6446)	1	1,404	3,095	YU136029	42956953A-2122	275	630	51	83	164	4.1	52	109	31	3	820	1817	2.4	
11GA / 48" X 120"	(7427-6446)	1	1,061	2,317	YU136029	42956953A-2123	275	630	51	83	164	4.1	52	109	31	3	820	1817	2.4	
11GA / 48" X 96"	(7427-6408)	1	1,398	3,082	YU136785	42956953B-11	290	659	51	84	169	4.3	47	119	28	9	806	1827	2.9	
AISI 304 NO.4																				
16GA / 36" X 120"	(7428-6064)	1	1,398	3,078	YU232690	41856329-22111	300	670	50	82	159	4.7	50	122	25	9	806	1813	2.9	

Remarks: NO MERCURY CONTAMINATION
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HERE IN HAS
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.

Bend test: good for all Heat NO.

PRODUCT IN ACCORDANCE WITH ASTM A240, A480,
A262E, ASME SA240, Q3766D.
P.O. NO.: 434470

YIEH MAU CORP.

Lin Kun Hsing
Manager of Quality Assurance Section

0007

MTR MINNEAPOLIS

INTEGRIS METALS

05/18/05 MON 07:33 FAX 604 272 0951

Integriss Metals 7/26/2005 5:33 PAGE 002/003 Fax Server

